

5/25

SPLIT

<b>DART AEROSPACE LTD</b>	Work Order: <b>23284 A</b>
<b>Description: Fuel Purge Canister</b>	Part Number: <b>D3262-041</b>
<b>Dwg: D3262 Rev. B</b>	Qty: <b>20 13</b>
Page 1 of 1	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler <b>Note: (1) D3262-041 consists of (1) D3262-1 (1) D3262-3</b>	JL	05.05.20	20
2	MV	Cut (2) blanks per (1) D3262-041 Cut blanks: 6.000" x 0.500" x 5.400" long Bar Material: 6061-T6/T651 (QQ-A-200/8 or 225/8) (M6061T6B0.500x06.000) <b>Identify for D3262-3</b> Batch: <b>M17002</b>	J.L	05/07/07	20
3	MV	Machine as per Folio FA457 and Dwg D3262 <b>Identify as D3262-3</b>	J.L	05/07/10	20
4	QC2	Inspect parts as they come off the CNC machine	J.L	05/07/10	20
5	QC8	Second check	J.L	05/07/10	20
6	MV	Deburr	J.L	05/07/10	20
7	MV	Cut D3262-1 to length as per Dwg D3262 Material: 6061-T6 (QQ-A-200/8 or 225/8) 5.00 OD x 0.125" wall (M6061T6T5.000W.125) <b>Identify as D3262-1</b> Batch: <b>B17002</b>	J.L	05/07/24	20
8	WA	Weld canister assembly as per Dwg D3262 using DT8739 to align fillings <b>Pick:</b> Qty Part Number Description Batch A/R Aluminum Rod <b>M17552</b> <b>M17192</b>	BE	05/07/28	20
9	QC5	Inspect weld and work to Step 8	J	05.08.04	20
10	QC5	Pressurize canister to 10 psi and submerge under water and check for leaks as per Dwg D3262.	J	05.08.11	17
11	FP	Chemical Conversion Coat as per QSI 005 4.1	ML	05.08.12	13
12	FP	Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3 <b>Ensure to mask threads</b>	FL	05.08.17	13
13	QC3	Inspect Powder Coat	ML	05.08.18	13
14	ST	Identify with Dart part number and batch number using a fine point permanent ink marker, then Stock	CY	05.08.18	13
15	AC	Cost / part: <b>118.45</b>	Syc	05.08.19	13
16	DC	Close W/O <b>116.92</b> Inspect Level 21	G	05/08/19	13

Rev	Date	Change	Revised By	Approved
A	04.09.02	New issue	KJ/JLM	
B	04.09.29	Added Steps 10-12; changed Step 16	KJ/JLM	
C	05.03.10	Removed P/O for liquid penetrant inspection	KJ/JLM	

RELEASED  
10/05/04/28



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
05.07.07		- update dimension sheet	J.L	05.07.07			

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05.07.07	2	<del>Wrong information in</del> <del>file "says" gal by max of</del> <del>400, should be 200</del> <del>mill was going to</del> <del>machine in use</del> OK E						
		<del>part</del> <del>part (one) has no</del> <del>chamber on top.</del> <del>Is part acceptable</del> OK E		<del>Not acceptable</del> <del>swap &amp; replace</del> OK E				

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA:   P   Date: 05/08/19

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

DART AEROSPACE LTD		Work Order:	23284
Description: Cap		Part Number:	D3262-3
Inspection Dwg: D3262	Rev: B	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.070 x 45°	+/-0.010	.070	✓		Vern	
0.45	+/-0.030	.440	✓		Vern	
R0.063	+/-0.010	.060	✓		r-gauge	
0.090	+/-0.010					
0.33	+/-0.030	.335	✓		Vern	
5.005	+0.010/-0.000	5.007	✓		Vern	
0.688	+0.015/-0.000	.692	✓		Vern	
3.250	+/-0.005	3.246	✓		Vern	
0.875	+/-0.010	.874	✓		Vern	
Ø0.516	+0.008/-0.000	.519	✓		Vern	
Ø5.190	+/-0.010	5.190	✓		Vern	
<del>0.83</del>	<del>+0.015/-0.000</del>					
Ø0.580	+0.005/-0.000	.580	✓		Vern	
<del>Ø5.005</del>	<del>+0.010/-0.000</del>					

Measured by: J.L	Audited by: E	Prototype Approval:	N/A
Date: 05.07.07	Date: 05.07.08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.03	New Issue P/O D3262-041	KJ/JLM	
B	05.04.28	Dimensions and tolerances revised	KJ/JLM	

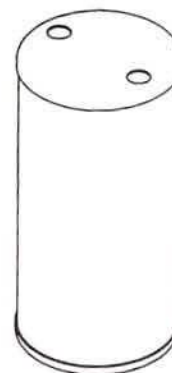
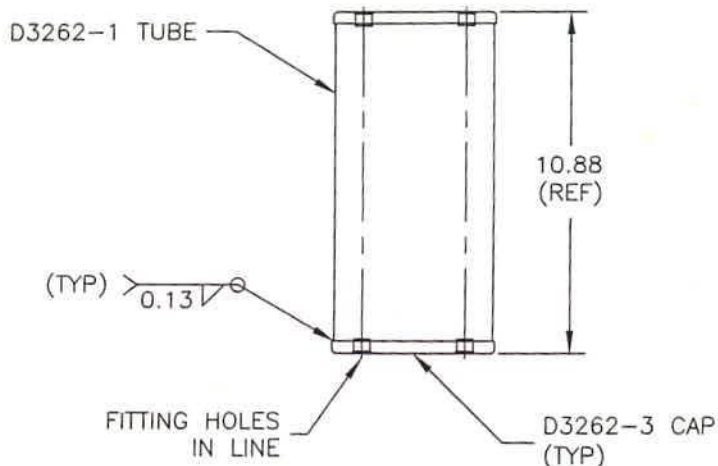
RELEASED  
05.04.28



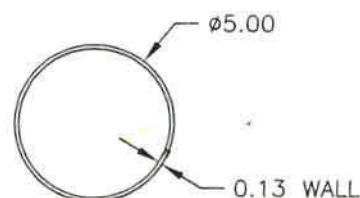
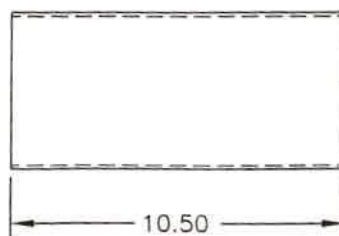


DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3262	REV. B SHEET 1 OF 2
DATE 05.02.14		TITLE FUEL PURGE CANISTER	SCALE 1:1
A	04.05.06	NEW ISSUE	
B	05.02.14	ADD PRESSURE TESTING OPTION	

RELEASED  
05.02.14



### D3262-041 CANISTER ASSEMBLY



### 1 D3262-1 TUBE

#### D3262-041:

- 1) MATERIAL: 6061-T6 (WW-T-700/6 OR QQ-A-200/8 OR QQ-A-225/8)  
TUBING 5.00 OD x 0.125 WALL (6061T6T5.000W.125)
- 2) WELD PER QSI 004.
- 3) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR PRESSURIZE TO 10 psi  
AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 8) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT INK MARKER

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NOTICE

WORK ORDER

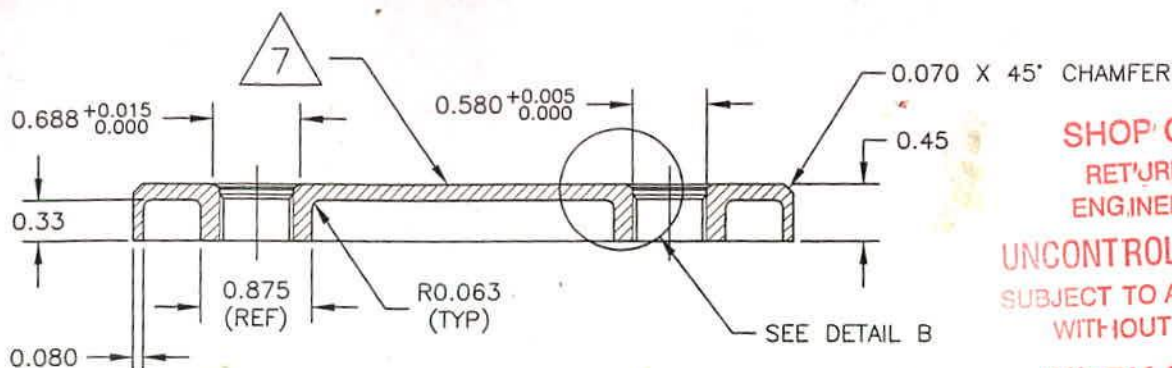
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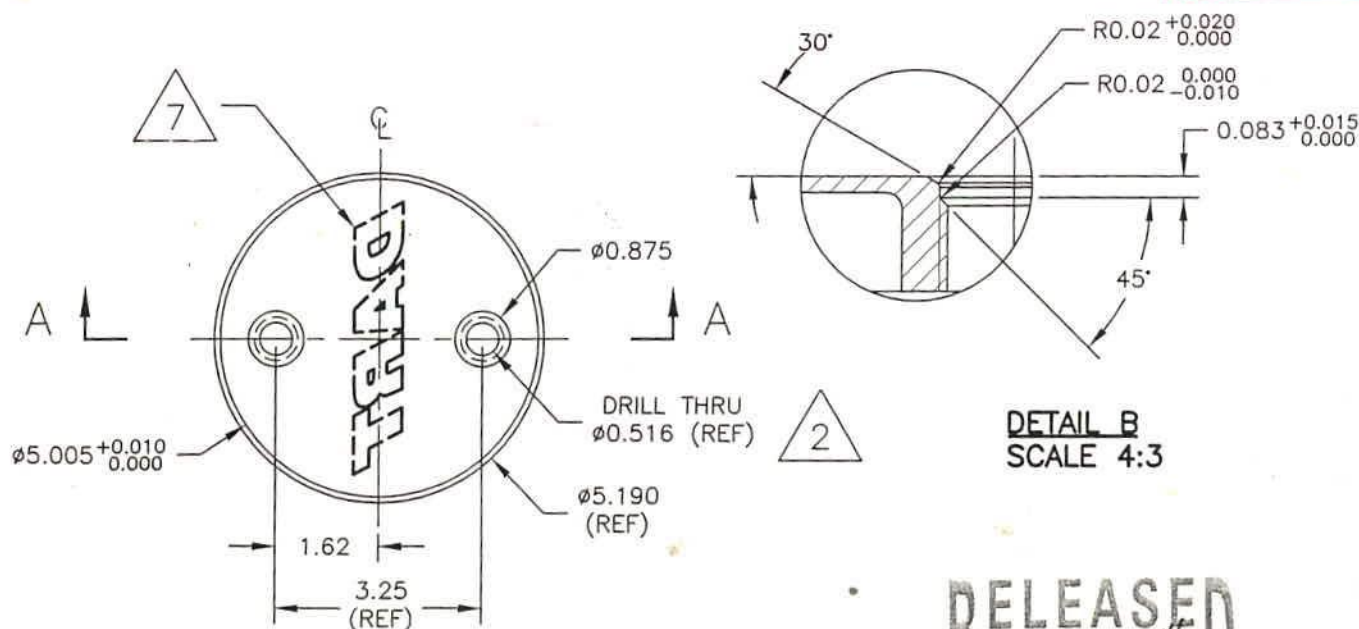


DESIGN [Signature]	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3262	REV. B SHEET 2 OF 2
DATE 05.02.14	TITLE FUEL PURGE CANISTER		SCALE 1:3



SHOP COPY  
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WORK ORDER  
NO. 23284



D3262-3 CAP

RELEASED  
05.02.14 [Signature]

D3262-3

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR  
(REF. DART SPEC. M6061T6B)
- 2) TAP HOLE 9/16-18 UNF-3B PER MIL-S-8879
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) PART IS SYMMETRIC ABOUT CENTERLINE
- 7) ENGRAVE DART LOGO AS SHOWN USING 0.75 HIGH X 0.010 DEEP  
(MAX) LETTERS WITH (MIN) TOOL RADIUS OF 0.25

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# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

May 12, 2005  
04:28 pm

Work Order No : 0023284  
Project Name : WK525  
Project For : D3262-041  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3262-041  
Description : Fuel Purge Canister  
Manufactured : Yes  
Amount Req'd : 20  
Amount Done : 0  
Start Date : 05-12-05  
Est Finish Date : 06-23-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Mark Up : 0.000%  
Actual Mark Up : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00